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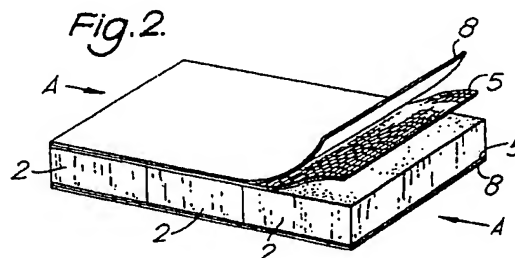
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54 Manufacture of mineral fibre products in layer form.

57 A layer product is made from an array of mineral fibre lamellae (2) compressed edge-to-edge. First, a retaining layer (8) e.g. of glass fibre cloth is secured to the compressed array to keep it compressed before a final outer layer (35) is applied. The retaining layer (8) is secured to the lamellae (2) using a layer of a heat-fusible plastics adhesive which gives an open adhesion pattern. Consequently the adhered retaining layer (8) allows good permeation of adhesive used to secure the stiff outer layers (35) to the faces of the assembly. Apparatus is described for continuous application of the retaining layer (8) to give an intermediate layer product.



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This invention relates to the manufacture of products in layer form, for example panels providing thermal and/or acoustic insulation or for constructional purposes. Generally the end-products have an inner layer of man-made mineral fibre bonded between relatively impermeable outer sheet layers.

For some years, constructional panels commonly consisted of foamed plastics between e.g. metal outer sheets. More recently, concern over fire risks and chlorofluorocarbon (CFC) risks associated with foamed plastics has led to increasing use of other inner layer materials. One such is man-made mineral fibre e.g. rock or glass fibre.

These fibre materials and their fire-proofing and insulating qualities are well known. They are generally commercially available in layer form in which, because of the manufacturing process, the fibres are oriented predominantly in one direction in the plane of the layer.

Firstly, fibre layers cannot be sandwiched directly between outer sheets to make panels because they have inadequate strength out of their own planes owing to the fibre orientation. The sheets would be liable to being pulled apart, disintegrating the fibre layer. Instead, it has become known to cut the fibre layer product into transverse slices, or "lamellae", in which short fibres lie transversely to the lamella plane. The lamellae can be laid flat in an edge-to-edge array and the outer sheets bonded to the surfaces they present. This provides the necessary layer integrity, but introduces difficulties of bonding to the "end-on" fibres in the lamellae. Also, the lamellae are generally only 100-200mm wide since that is the maximum commercially available thickness of fibre layer material. Therefore many lamellae are needed to make a panel of any substantial size.

Secondly, since the insulation properties of the panels are usually important, it is important to avoid gaps between lamellae. This problem has already been addressed in the known art by compressing the lamellae edge-to-edge in an array before they are incorporated in the layer product. To keep the array compressed, it is known to spread intermediate retaining layers of e.g. glass fibre fabric over one or both faces, sticking them on using spray-applied adhesive, so that the array can subsequently be removed from the compression means and handled as a separate intermediate product. The outer sheet layers (e.g. of metal) are stuck on later, using an adhesive which penetrates to some extent through the open glass fibre fabric and onto the lamellae. However, secure bonding is difficult to achieve.

The particular problem addressed here is to provide a new manner of making the intermediate layer product, enabling improved manufacture of

the final product particularly regarding the bonding.

In one aspect of the invention, we stick the intermediate retaining layer onto the edge-to-edge compressed array of lamellae using a heat-fusible layer adhesive e.g. in the form of a net or web. This differs from the previous technique of spraying wet adhesive onto the fibres in that it produces an open pattern of adhesion overall - usually either a network of fused filaments, or spots regularly spaced from one another - rather than flooding the fibre ends at the lamella surface as in the prior art. As a result, penetration of secondary adhesive into the lamellae, past the first adhesive, is greatly improved when the final outer sheet layers are bonded on. Consequently, the final product can be much stronger.

Heat-fusible nets and webs for adhesive purposes are known, and the skilled man will be able to select a type appropriate for the fibre material and intermediate retaining layer material used. Suitable fusion temperatures might be, for example, in the range 80°-160°C.

Generally a "net" means a regular layer of crossing filaments, usually fused together at their crossings although they may cross freely as in a woven fabric.

Conversely, "web" is used here with its usual sense in this adhesive art i.e. as meaning a layer of filaments substantially randomly arranged to give a tissue of relatively open structure.

As mentioned above, these are known materials, and are known for sticking together e.g. two fabric layers in clothing so that air can permeate through. The present invention is new in applying them to mineral-fibre layers, and with the novel purpose of allowing a further adhesive to permeate through and adhere a further layer all the way through to the fibre substrate.

The retaining layer may be of a type already known, e.g. a coarse weave glass fibre fabric providing fairly high permeability. However, other materials are possible. In one version, the retaining layer comprises a non-fusing plastics net laid over the heat-fusible layer, and having a higher melting point so that it is substantially undamaged by the temperature required to melt the adhesive layer. In a possible refinement of this version, the retaining layer is a plastics net formed integrally with the fusible adhesive. The net filaments may be co-formed e.g. by coextrusion, to consist of two different plastics having different melting points. With appropriate selection of the respective melting properties and thickness of the two co-formed filament components, a net can be produced which is laid as a single layer onto the lamellae and subjected to heating at a predetermined temperature. As a result, the lower melting point plastics fuses and adheres the other plastics (which retains its

integrity as a net) to the lamella array. Coextruded nets of this type are commercially available.

A net-type plastics retaining layer is more easily and uniformly penetrated by the adhesive used to bond the outer sheets. It is also cheaper. However, fabrics have a strength advantage.

The invention includes both the method of applying the retaining layer to form an intermediate inner layer product, and the inner layer product itself. It also extends to the final panel product including the outer sheets, and the process of making the panel products incorporating the process of preparing the inner product as described.

In another aspect, the invention provides apparatus comprising means for making the intermediate layer products. In a preferred apparatus, lamellae are fed sequentially to a first conveyor which conveys them to a transition to a second conveyor which imposes on them a slower conveying speed. The conveyors grip the lamellae sufficiently firmly for the change in speed to cause them to be compressed together, in the conveying direction, at the transition from one conveyor to the other. The retaining layer material, for holding the lamellae compressed in the intermediate product, may be laid onto them at or near the transition point, or at some subsequent station at which they are still in their compressed state.

In this way, it is possible to prepare the layer product in a continuous manner, whereas previously it was necessarily made in batches with the lamellae compressed by a frame or the like. Therefore there are advantages of speed and economy.

The fusible adhesive layer may be laid into the conveyor path, for example from a roll, at or after the compressing transition. The retaining layer itself (where not in one piece with the adhesive) may be laid on at the same station or subsequently. Means are preferably provided for heating to cause the fusing of the adhesive and adhesion of the retaining layer. A heating station or stations may be provided and/or subsequent to the location of the application of the fusible layer. Preferably heating occurs as the layer is engaged by a conveyor. This may be a separate heating conveyor following the second, or may be the second conveyor itself.

Possible means for heating include infrared radiation, which has the advantage that it can be cheaply and uniformly e.g. through an IR-permeable conveyor structure. Heated elements, e.g. hot rollers, are also useful. A combination of the above may be used.

The retaining layer may be applied over the fusible layer either before or after fusing thereof.

The conveyors themselves are advantageously belts or rollers, in particular opposed belts, opposed rollers or opposed sets of rollers between which the lamellae can be gripped positively.

Normally the retaining layers and adhesive will be applied to the lamella array on both faces simultaneously. In some cases, particularly where a curved panel is desired, a layer may be applied on one face only.

One or more stabilising elements, e.g. plates, bars, rollers, or running belts, may be provided adjacent the conveyor path at transition(s) between conveyors to reduce any tendency of the lamellae to buckle under compression.

Also, cooling means may be provided downstream of the heating means. In some cases, ambient cooling along the conveyor path may suffice. In other cases, it may be preferred to provide cooling apparatus such as cooling blowers and/or cooled rollers or belts.

Embodiments of the invention are now described by way of example, with reference to the accompanying drawings in which:

Fig. 1 shows a mineral fibre product and lamellae;

Fig. 2 shows three lamellae, adhesive layers and retaining layers being made up into an intermediate inner layer product;

Figs. 2a and 2b show fused adhesive patterns.

Fig. 3 shows the intermediate layer product;

Fig. 4 shows enlarged a co-extruded net filament;

Fig. 5 shows schematically an apparatus for forming the intermediate layer product;

Fig. 6 shows a different form of apparatus, and

Fig. 7 shows a final layer product.

In Figure 1 is shown a piece 1 of commercially available mineral fibre layer e.g. "Rockwool" (trade mark), a rock fibre made by Rockwool International. The drawing indicates how the packed fibres of the material are oriented primarily longitudinally in the plane of the layer. By cutting the material into transverse slices - see the broken line - the commercial material can be converted into lamellae 2, usually 100-200 mm wide and 1000-1500 mm long.

Fig. 2 shows lamellae 2 positioned edge to edge and held compressed in direction A by a known compressing device (not shown) such as a retaining frame. For purposes of illustration only three lamellae have been shown, but in reality the number might be 5-20, resulting in a product perhaps 1-2 m long, 1-1.5 m wide.

Two layers are being spread over the surface of the three-lamella array. The layer 5 being spread directly onto the surface is a heat-fusible plastics net, such as are commercially available from Smith & Nephew Plastics Limited. A retaining or holding layer 8, e.g. a glass fabric, is superimposed on the plastics net 5 and spreads over the array. One suitable fabric has weight of 64 gsm, strand thickness 0.13 mm, warp no. = 89 and weave no. = 82. Subsequently heat is applied onto the holding layer

8, e.g. using a heated belt or platen, at a temperature of from e.g. 80-160°C, with the result that the net fuses and sticks the holding layer 8 onto the surface of the array. Figs. 2a and 2b show that, on fusing, the net 5 may either keep its network form, or form a pattern of fused spots 6 corresponding to the nodes of the net.

Since the mesh of the net 5 is generally small, i.e. of the order of 2 mm or less, a very large number of fused adhesive spots 6 or filaments 7 are formed, nevertheless allowing a good permeability through to the end-on fibre surface of the lamellae. The holding layer 8 is sufficiently strong and well stuck to keep the lamellae 2 in their compressed condition. Usually a corresponding holding layer 8 is applied to the opposite surface of the array. The two holding layers 8 may be applied separately or simultaneously. The result is an intermediate inner layer product 10 of the type shown in Fig. 3, which can itself be transported or stored for subsequent make-up into panels as will be described below.

Instead of a net of fusible adhesive, it is possible instead to use a web with a random filament arrangement. The choice of material for the web depends on the process conditions to be used and on the material of the retaining layer. These heat-fusible adhesive webs are commercially available materials e.g. under the trademark SHARNET from Applied Extrusion Technologies Inc. of Middletown, Delaware, USA. Webs are available made of polyester, polyolefin, polyamide or polyurethane.

In another embodiment the holding layer 8 is not a glass cloth but a plastics net able to withstand the heating conditions used to fuse the adhesive net. A suitable holding net might be made, for example, of polypropylene of mesh size 1-3 mm. Once stuck on, the resulting surface structure is highly permeable.

A further option is to use only a single net material for each face of the array, consisting of two types of plastics material coextruded together. Fig. 4 shows schematically a filament 15 from such a material with an upper plastics material 16 e.g. polypropylene, of high melting point and a lower plastics material 17 of lower melting point which may be e.g. polyethylene or a complex polymer. A layer of this is applied to the surface of the lamella array and heat applied, whereupon the low melting point plastics fuses and sticks the net of high melting point plastics to the fibre material. The high melting point net then serves as a holding layer 8 for the compressed lamellae 2.

Figure 5 shows schematically an apparatus for continuous production of intermediate layer material. The apparatus comprises (from right to left) a feed conveyor 19, a pair of gripping belts 20, a pair of heating belts 21 and a pair of cooling belts 22.

The conveyor and belts are driveable at predetermined speeds to convey lamellae 2 along a path P from right to left. The heating belts 21 and cooling belts 22 are arranged to be driven more slowly than the gripping belts 20, by about 5% for example but in any case controllably. In each pair of belts the belts are spaced so that the lamellae 2 are gripped firmly between them, with the consequence that the belt speed is imposed on the lamellae. The transition gap between the gripping and heating belts 20,21 is provided above and below with a pair of longitudinal stabilising elements 25, shown as flat plates above and below the conveyor path.

Positioned above and below the conveyor path adjacent the transition gap are mountings for rolls of heat-fusible plastics net material (inner rolls) 28 and for retaining or holding layer material (outer rolls) 29. The material from the rolls is led into the nip of the upstream end of the heating belts 21, with the retaining layer material 8 outermost.

In operation, lamellae 2 are fed continuously edge-to-edge into the gripping belts 20 by the feed conveyor 19. The gripping belts convey them to the transition gap where they pass into the heating belts 21, which impose on them a slower speed. As a result, the lamellae 2 are compressed together in the direction P, and the grip of the belts prevents them from sliding out of compression. The stabilising elements 25 at the transition prevent them from buckling out of the conveyor path as they are first compressed. Simultaneously with entering the heating belts 21, the two layers 5,8 described are applied to the two faces of the now-compressed series of lamellae. Heaters 30 provided in the heating belts cause the fusible net to fuse, thereby sticking the holding layer onto the lamellae.

Finally, the composite layer passes from the heating belts 21 to the cooling belts 22 which travel at the same speed, where the bond formed by the fused adhesive is finally set. An additional set of stabilising elements 26 prevents buckling at this point also. The layer product 10 emerges at the end and can be cut into suitable lengths for storage, transport or immediate make-up into panels.

The operation of the embodiment of Fig. 5 is dependent on there being little or no slip between the lamellae 2 and the heating belts 21. However, it is desirable to have a heating belt surface which will not stick while withstanding heat. Polytetrafluorethylene is a suitable material, but is rather slippery. The result is that the thrust caused by attempted compression of the lamellae entering the heating belts produces slipping and ineffective compression.

Fig. 6 shows a modification which does not have this problem. An extra set of gripping belts 124 is provided before the heating belts, the sec-

ond set 120 being driven slower than the first 124. The heating belts 121 are driven at the same speed as the second set of gripping belts 120. As a result, compression of the lamellae 2 occurs at C between the two sets of high-friction gripping belts and they are already compressed when they arrive at the transition to the heating belts. The compression thrust is taken up between the two sets of gripping belts and cannot cause slipping at the heated stage.

For making up into panels, outer sheet layers 35, e.g. steel or aluminium sheets, are applied to the two faces of the layer product and stuck to it using a foaming adhesive such as a filled foaming polyurethane. This foaming adhesive penetrates through the open structure provided by the holding layer and fused adhesive, and into the fibrous surface region all over the lamella array. This provides a secure bond to hold the final product, e.g. a building panel 11, together.

It will be appreciated that the apparatus described above and corresponding method steps may be modified in a number of ways.

For example, the apparatus described uses belt conveyors for moving the lamellae along the conveyor path. However, we envisage that all or some of these conveyors may instead be rollers. In particular, opposed series of powered rollers can be used.

The embodiment of Fig 6 illustrates that the location of applying the adhesive and retaining layers is variable. It should also be appreciated that these layers need not be applied at the same station. The application of the adhesion layer 5 may be spaced substantially upstream from that of the retaining layer 8. Indeed, these locations may be separated by one or more conveyors. Such a conveyor between the locations may include heating means so that the adhesive layer can be heated without the retaining layer 8 in between. To prevent undesirable adhesion of heated adhesive to the conveyor, the conveyor e.g. rollers or belts can be provided with a non-stick surface e.g. PTFE.

In the above description, the heaters 30 are not described in great detail. One useful possibility is to use infrared radiation directed onto the conveyor path. This might be at an open section of the path, or through a conveyor as shown. A conveyor with a belt can be made with an open mesh to allow this. In particular, this works best when the radiation acts on the adhesion layer 5 as yet uncovered by the retaining layer 8.

Another possibility for heating the adhesive is the use of hot rollers. These might be heated by steam or hot liquid in a known manner, or by electrical filaments.

The provision of accurately uniform heating using hot rollers is more difficult and expensive

than the use of infrared radiation. Therefore one proposal is to use radiation for an initial phase of the heating e.g. towards but not over the melting point of the adhesive, and then use a hot roller or rollers to cause the final melting. Such a hot roller could be inserted e.g. at a position corresponding to that of the interrupter element 26 in Fig 5.

In the embodiments shown in the figures, cooling of the intermediate product after adhesion of the retaining layer occurs simply by ambient heat exchange. The non-heated rollers 22 help this. However it is possible also to provide specific means for cooling the product more quickly. One possibility is cooled rollers e.g. a single large roller cooled by recirculating refrigerated water. Another possibility, which could be used in combination, is the blowing of cold air onto the intermediate product as it passes along the conveyor path. As with the infrared radiation, air could be blown onto the product through an open-weave fabric conveyor belt, or between rollers of a conveying set.

Claims

1. A method of making an intermediate mineral fibre product in which a permeable retaining layer (8) is adhered to an edge-to-edge compressed array of mineral fibre lamellae (2), characterised by adhering the retaining layer (8) to the lamella array by fusing a plastics adhesion layer (5) to form an open, permeable adhesion pattern between the retaining layer (5) and the lamellae (2).
2. A method according to claim 1 in which the adhesion layer (5) comprises a net or web.
3. A method according to claim 1 or claim 2 in which the retaining layer (8) comprises a glass fabric or a plastics net.
4. A method according to any one of the preceding claims in which lamellae (2) are continuously formed into the compressed array by conveying them sequentially from a first conveyor (20) to a second conveyor (21) which imposes on the lamellae (2) a conveying speed slower than that of the first conveyor (20), thereby compressing the lamellae (2) together in the conveying direction.
5. A method according to claim 4 in which the adhesion layer (5) and retaining layer (8) are applied continuously to the conveyed series of compressed lamellae (2).
6. An intermediate layer product comprising a retaining layer (8) adhered to at least one face

of an array of compressed mineral fibre lamellae (2), obtainable in accordance with any one of claims 1 to 5.

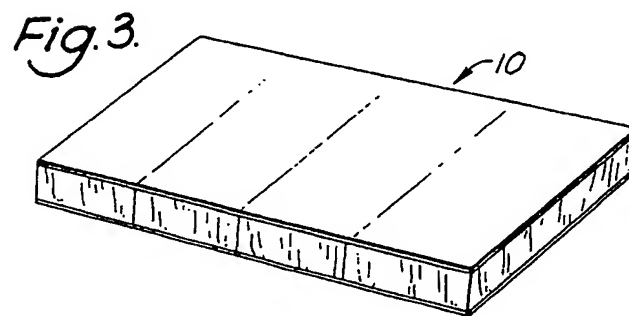
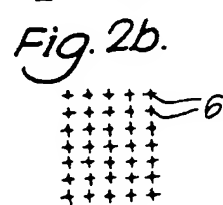
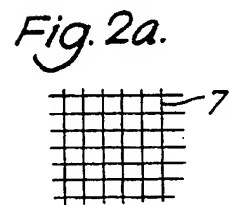
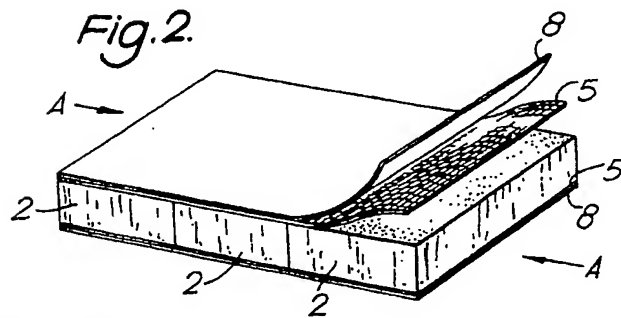
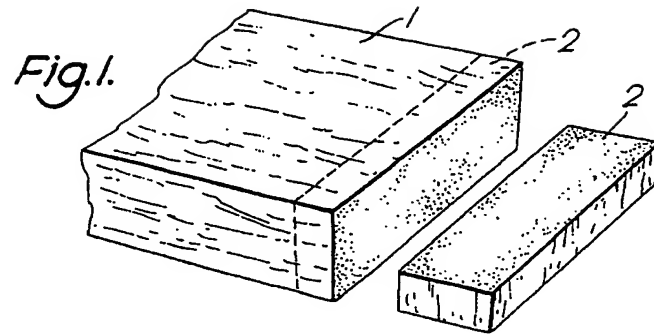
7. A method of making a mineral fibre panel product (11), comprising adhering a stiff outer layer (35) to one or both faces of an intermediate product according to claim 6 with an adhesive which penetrates through the retaining layer (8) and adhesion pattern of the intermediate product and into a fibrous surface region of the array of lamellae (2). 5
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8. Apparatus for making an intermediate mineral fibre layer product, comprising 15
 - means (20,21) for compressing an edge-to-edge array of mineral fibre lamellae (2);
 - a heat-fusible adhesion layer supply, and
 - means (28) for applying the adhesion layer to at least one surface of the compressed lamella array; 20
 - means (29) for applying a permeable retaining layer (8) to said at least one surface of the lamella array, either together with or separately from the adhesion layer (5), and 25
 - at least one heater (30) for fusing the adhesion layer (5) so that the retaining layer (8) is adhered to the compressed lamella array.
9. Apparatus according to claim 8 having a conveyor path along which the lamellae (2) are conveyed continuously, with a faster conveyor (20) leading to a slower conveyor (21) whereby in use lamellae (2) on the conveyor path are compressed between the faster and slower conveyors (20,21). 30
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10. Apparatus according to claim 9 comprising retaining elements (26) between conveyors (20,21,22) of the apparatus, for resisting buckling of the compressed lamellae (2) away from the conveyor path. 40

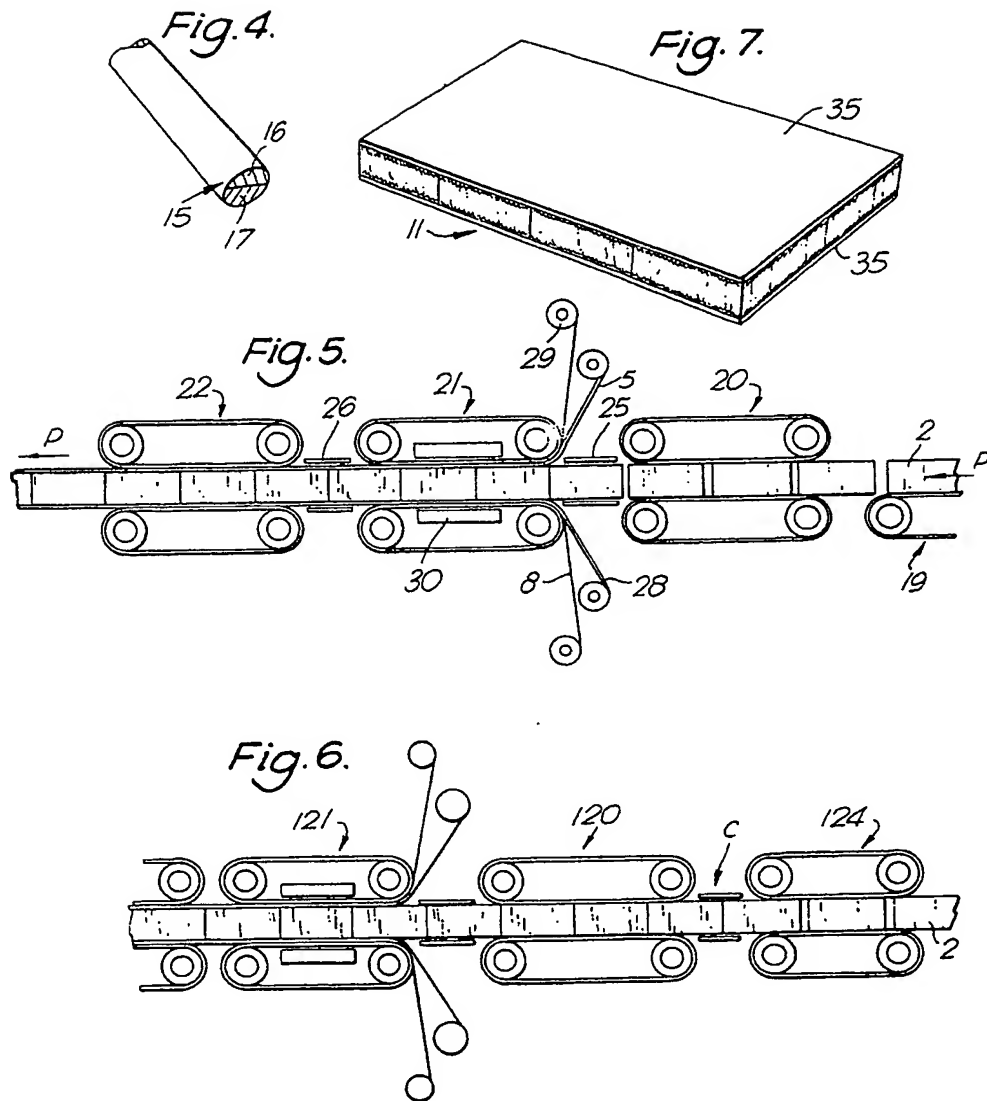
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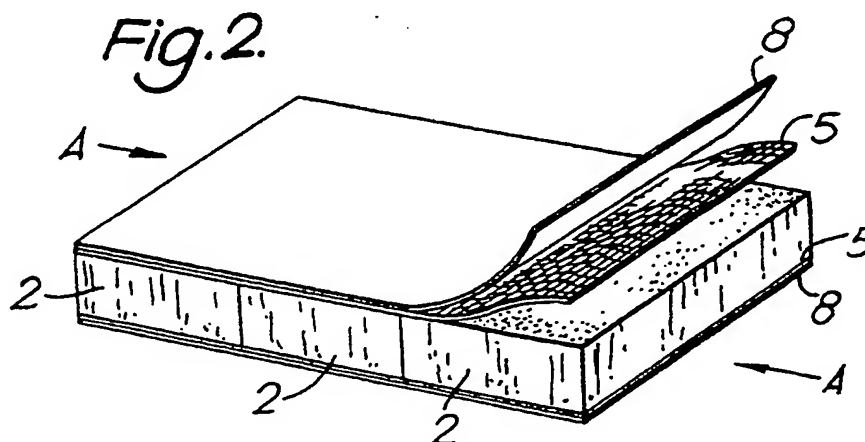
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(54) **Manufacture of mineral fibre products in layer form.**

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an open adhesion pattern. Consequently the adhered retaining layer (8) allows good permeation of adhesive used to secure the stiff outer layers (35) to the faces of the assembly. Apparatus is described for continuous application of the retaining layer (8) to give an intermediate layer product.





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EUROPEAN SEARCH REPORT

Application Number

EP 91 30 1328

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. CL.5)
X	EP-A-0 017 969 (IHLEFELD) * Page 6, line 28 - page 7, line 17; claims 1,3,5 *	1-3,5,6	B 32 B 31/00 B 32 B 19/06 // E 04 C 2/16
Y	* Page 3, lines 15-26; claims *	7	
X	FR-A-2 592 416 (FIBRACONSULT) * Page 4, lines 16-21; claims 1,2,10; figures 1-6; page 5, lines 5-15 *	1,3,5,6	
P,X	DATABASE WPIL, accession no. 90-104981 [14], Derwent Publications Ltd, London, GB; & JP-A-02 057 333 (SEKISUI) 27-02-1990	1,2,6	
P,X	FR-A-2 639 386 (GREGOIRE) * Claims 1-3; figure 2 *	6	
P,A	* The whole document *	1-3	
X	DE-A-2 303 320 (NOLCO) * Page 3, paragraph 2; claims 1,4 *	6	
A	* The whole document *	1,3	TECHNICAL FIELDS SEARCHED (Int. CL.5)
A	FR-A-2 418 082 (ROCKWOOL INTERNATIONAL) * Page 1, line 25 - page 2, line 17; claims; figures *	1,5	B 32 B E 04 C G 10 K E 04 B B 29 C
A	DE-U-8 532 239 (DEUTSCHE HERAKLITH) * Page 5, paragraph 5 - page 6, paragraph 1; claims 1-3,5; figures * -/-	1,3,6	
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 12-09-1991	Examiner VAN WALLENE A.M.A.
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	



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CLAIMS INCURRING FEES

The present European patent application comprised at the time of filing more than ten claims.

- ☐ All claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for all claims.
- ☐ Only part of the claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims and for those claims for which claims fees have been paid.
- namely claims:
- ☐ No claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims.

☒ LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirement of unity of invention and relates to several inventions or groups of inventions.

namely:

See sheet -B-

- ☒ All further search fees have been paid within the fixed time limit. The present European search report has been drawn up for all claims.
- ☐ Only part of the further search fees have been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the inventions in respect of which search fees have been paid.
- namely claims:
- ☐ None of the further search fees has been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the invention first mentioned in the claims.
- namely claims:



DOCUMENTS CONSIDERED TO BE RELEVANT															
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)												
A	DATABASE WPI, accession no. 79-28691B [15], Derwent Publications Ltd, London, GB; & JP-A-54 029 383 (DIABOND KOGYO K.K.) 05-03-1979 ---	1,2													
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X	US-A-4 632 685 (DEBOUZIE et al.) * Column 8, lines 51-57; claim 4 * ---	4													
Y		8-10													
Y	US-A-3 082 143 (SMITH) * Claims; figures * ---	8-10													
A	US-A-4 567 078 (BLACKMORE et al.) * The whole document * ---	4,8-10	TECHNICAL FIELDS SEARCHED (Int. Cl.5)												
A	FR-A-2 393 680 (ARMSTRONG CORK CO.) * The whole document * -----	1-6,8-10													
The present search report has been drawn up for all claims															
Place of search THE HAGUE		Date of completion of the search 12-09-1991	Examiner VAN WALLENE A.M.A.												
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LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirement of unity of invention and relates to several inventions or groups of inventions, namely:

1. Claims 1-3,5,6: Intermediate layer product and method of making the same.
2. Claim 7: Method of adhering stiff outer layer to layered product.
3. Claims 4,8-10: Method and apparatus to compress mineral fibre lamellae prior to bonding retaining layer.

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